

Work Order ID 83072

April-12-12 4:08:23 PM

83072

Page 1

Item ID: D206-559-021

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bearpaw

Start Date: 12/04/2012 Start Qty: 3.00

3

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

MLJ

Date:

12/04/13

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D206-559

rev L

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D206-559-021 CHG007

0.00

0.00

Sc 12/6/1

MLJ 12-5-1
(3)

160

160

Packaging

Packaging

Pick Kit

Memo

0.00

0.00

(3)

12/4/13
Q

170

170

QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00

Sc 12/6/1

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D206-559-021

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bearpaw

Stop ***NS2***

Start Date: 12/04/2012 Start Qty: 3.00 ***3***

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 3.00 ***3***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

0.00

180

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD206-559-021 Location:

3x

12-05-02

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/15/11

mf 12-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 83072

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Parent Item: D206-559-021

D206-559-021

Parent Item Name: Bearpaw

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP Rev:C04.02.17Blank size changedKJ/JLM

IPP Rev:D 07-01-02 Was K10005 JLM

IPP Rev:E 08-01-09 Added Step 2 JLM Verified By:EC

IPP Rev:F 08-05-05 up a chg DD verified by:EC

IPP Rev:G New Manufacturing Method 08-10-29 JLM Verified By:EC

IPP RevH 10.10.04 per DSI9527 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-17A		Purchased	No			160	Each	490.0000	8	24			

AN4-17A

Location

Loc Qty

Loc Code

ST358

16

116419

16

116704

0

ST359

474

112314

0

118983

74

121011

200

121068

200

AN4-20A

Purchased

No

160

Each

473.0000

8

24

AN4-20A

Location

Loc Qty

Loc Code

GA

50

116419

50

ST359

423

115936

3

117514

51

119127

169

121060

200

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 83072

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Parent Item: D206-559-021

D206-559-021

Parent Item Name: Bearpaw

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 3.00

Required Qty: 3.00

AN960JD416 NAS1149D0463J Purchased No

160 Each

10.0000

AN960JD416

Washer

16 48
**

M1212555 SP

Location

Loc Qty

Loc Code

ST351

10

116289

10

D2182B Manufactured No

160 f

263.5132 1.67 5.01

D2182B

Rubber Cushion

**

SP

SP

Location

Loc Qty

Loc Code

ST410

263.51317

63413

1.6

66063

41.61817

73932

220.295

(D2182B050)-cut qty (4) at 5.00" as per dwg ***per kit***

D2274 Manufactured No

160 Each

426.0000

D2274

Radius-Block

**

8 24

B73389

f SP

Location

Loc Qty

Loc Code

ST007

426

78233

26

81958

400

D2438 Manufactured No

160 Each

10.0000

D2438

Clamp

**

4 12

24130P

B87966

SP

Location

Loc Qty

Loc Code

ST456

10

77038

6

81486

4

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 83072

Parent Item: D206-559-021

Parent Item Name: Bearpaw

83072

D206-559-021

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 3.00

Required Qty: 3.00

D2529

Manufactured No

160 Each

443.0000

D2529
Washer

**

8

24

200
7/1/61

SP

Location

Loc Qty

Loc Code

ST010

443

79485

18

81873

425

Manufactured No

160 Each

0.0000

D2671

D2671

Bearpaw, 206 Narrow
MS21042L4

**

2

6

803072 SP

Purchased No

160 Each

3,733.000

MS21042L4

**

8

24

SP

Location

Loc Qty

Loc Code

ST300

3733

116188

5

119017

4

119075

1724

121011

2000

Purchased No

160 Each

61.0000

QS200-M44S

QS200-M44S

Clamp

**

2

6

12/4/30 SP

Location

Loc Qty

Loc Code

ST455

61

115410

2

115589

3

117460

13

119436

18

121068

25

2
2
2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP